



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3199-1
Job Sheet 168139



Part No: D3199-1

Job Qty: 40 ea

Part Name: Bracket



Part Weight: 0 lbs

Job Created: 11/10/17

Due Date: 11/14/17

Type: SOLD

Customer: Bell Helicopters (CBELL04)

Just

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Canadian Supply Centre, Bay 101, 58 Aero Drive NE Calgary, AB, T2E 8Z9 Canada ph:(403) 275-3555

Note: DWG REV E SHEET 1 IPP Rev:C Removed Scribing 05-11-05 JLM IPP Rev:D As per Rev B 06-11-24 JLM
IPP Rev:E 11.03.31 as per ecn 11-531 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		11/13/17	0.00	0.00	Start Up Waterjet1		<i>DL</i>
100	Waterjet	40 pcs		11/13/17	0.00	1.18	Waterjet1		<i>DL</i> <i>DAS</i>
120	QC	40 pcs		11/13/17	0.00	0.00	QC8		<i>38</i>
130	Small Fab	40 pcs		11/13/17	0.01	1.76	Small Fab		<i>38</i> <i>9-BA</i>
140	QC	40 pcs		11/13/17	0.00	0.00	QC5		<i>38</i>
150	Powdercoat	40 pcs		11/14/17	0.00	0.45	Powdercoat3		<i>38</i> <i>DAS</i>
160	QC	40 pcs		11/14/17	0.00	0.00	QC3		<i>38</i> <i>DAS</i>
170	Packaging	40 pcs		11/14/17	0.00	0.00	Packaging3	<i>Stop 22 NOV 16 2017</i>	<i>38</i> <i>9-BA</i> <i>6</i>
180	QC21-SA	40 Ea		11/14/17	0.00	0.00	QC21		<i>21</i> <i>9-BA</i> <i>6</i>

Part Op 100 - Cut as per Dwg D3199 Deburr if required

Descriptions: 130 - Form as per dwg D3199 use DT9723

150 - START TIME: *7:45* FINISH TIME: *8:15* OVEN T: *520* M136370.

NOV 16 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S20GA	4 <i>138175=2</i> <i>137762=2.9</i>	135	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.210inches + 0.005 - 0.001	0.215 0.209		
2	Bracket	0.575inches ± 0.010	0.585 0.565		
3	Bracket	1.090inches ± 0.010	1.100 1.080		
4	Bracket	2.015inches ± 0.010	2.025 2.005		
5	Bracket	2.971inches ± 0.010	2.981 2.961		
6	Bracket	1.830inches ± 0.010	1.840		

DART
AEROSPACE
S009143



Bracket

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO:
Revision:
Operation:
Change No:

D3199-1

Start up Operation

Mfg Date: 11/13/17
Job No: 168139

			1.820
7	Bracket	4.830inches $\pm$ 0.010	4.840 4.820
8	Bracket	4.030inches $\pm$ 0.010	4.040 4.020

Plex 11/10/17 8:44 AM dart.lacelle.linda

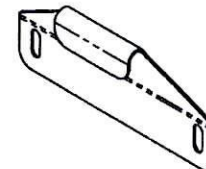
168139

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:		Audited by:	38	Preliminary Approval:	
Date:		Date:	NOV 13 2017	Date:	

Rev	Date	Change	Revised by	Approved
A	06.10.20	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	11.03.08	Dwg Rev updated	KJ	
D	12.02.06	Dwg Rev updated	KJ	



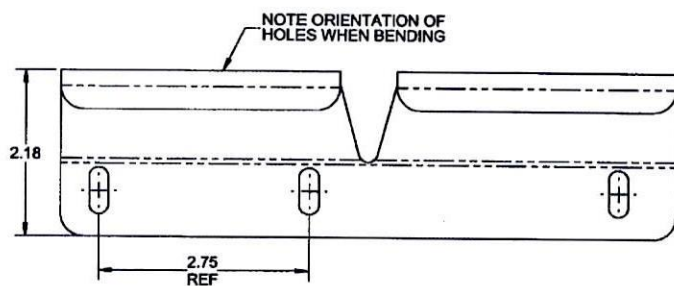
Technical drawing of a rectangular box with a lid. The height of the box is labeled as 2.24.

Technical drawing of a mechanical part with dimensions: 15° REF, R0.17, 0.41, 0.68, 0.96, and R0.25.

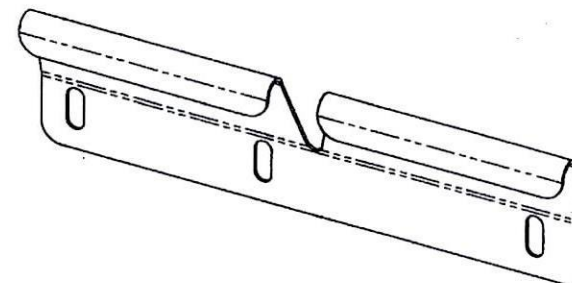
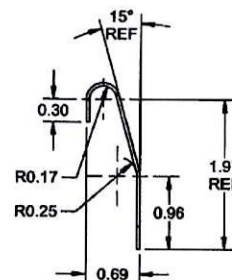
RELEASED
2011-07-18

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/4 = 0.26 lbs EACH

E	RE-DESIGNED D3199-3/4-3F PER CUSTOMER FEEDBACK TO OPT MFG FIT.	MB	11.07.11
D	RE-DESIGNED D3199-3/4-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF.: PART11-78	MB	11.03.21
C	ADD -3/4 PART (SHEET 2-4)	HS	06.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	06.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D3199	
DATE		TITLE BRACKET	
		REV. 1 OF 1	
		SCALE NT	
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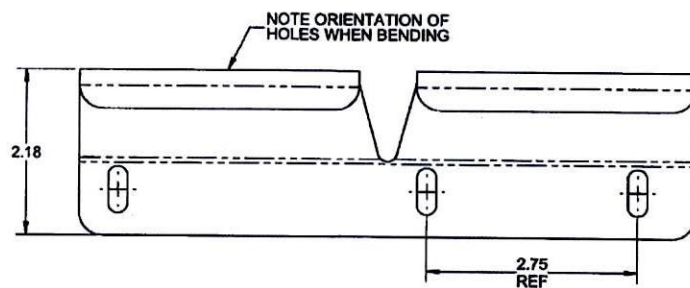


D3199-3 BRACKET
MADE FROM D3199-3F

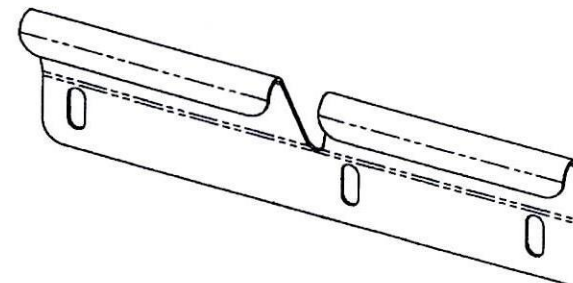
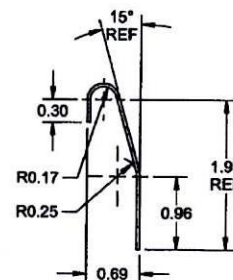


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MFG. APPR.		D3199	SHEET 2 OF 4
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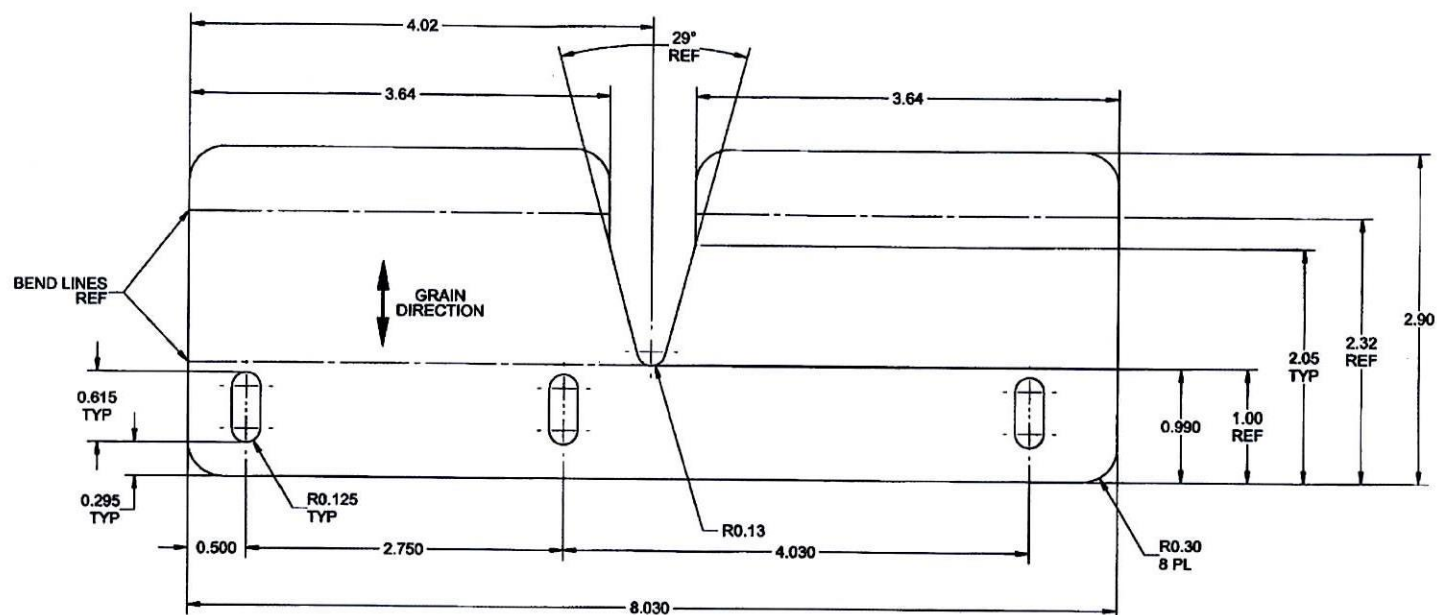


D3199-4 BRACKET
MADE FROM D3199-3F



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2011-07-18
JW

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MFG. APPR.		D3199	SHEET 3 OF 4
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D3199-3F FLAT PATTERN

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2011-07-18

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.25 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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